

20-8305



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

POSITIVE RECALL

EFFECTIVE 20/11/11 AUTH: S.A.
RELEASED DAS DATE 20-11-8
9-89



D3140-303

Job Sheet 212142



Part No: D3140-303

Job Qty: 1 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/11/20

Job Tracking No:

Due Date: 8/13/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV F IPP rev A 02.11.06 New issue KJ/RF IPP Rev B IPP rev.C 06.04.25 Waterjet EC IPP rev.D added
scuffing NCR 061 EC IPP Rev:E As per ECN #829 06-11-20 JLM

Ship Via: D3140-303 Carlson

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	1 pcs		8/12/20	0.17	0.05	Waterjet - Flow	JRH /		on 20/08/12
110	QC 2	1 pcs		8/12/20	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			

S.A. / on 29/08/12

120 QC 8	1 pcs	8/12/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
130 Small Fab - 2 - B4B	1 pcs	8/12/20	0.00 0.17	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
140 QC 5	1 pcs	8/12/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	

DAS
AUG 17 2020
9:59

SAA
20/08/20

					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	20-8-12
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
150 Handfinish - 1-1 Chemical-B4B	1 pcs	8/13/20	0.00 0.11	Handfinish - 1 - 1 - B4B		
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
160 QC 3	1 pcs	8/13/20	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
				QC 3 - 82		
				QC 3 - 87		
				QC 3 - 47		
170 Packaging 3-1 - Stock - B4B	1	8/13/20	0.00 0.00	Packaging 3 - 1 - B4B		

POWDER COAT.
~~M156440~~
 START: 9.00 A.T. 3.30 FINISH 9.30

DAS
 AUG 13 2020 40
 9-80

170 Packaging 3-1 - Stock - B4B

1

8/13/20

0.00 0.00

Packaging 3 - 1 - B4B

POWDER COAT

Black Sandtex
 as per Deception

2008-13

8/13/20

12:08 PM Dart.Renwick.Jennifer

pcs				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		DAS
				Packaging 3 - 11 - B4B		21
				Packaging 3 - 12 - B4B		9-89
				Packaging 3 - 13 - B4B		AUG 18 2020
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 37 - B4B		
180 QC 21 - SA	1 pcs	8/13/20	0.00 0.00	QC 21 - SA - 21	DAS	AUG 18 2020
				QC 21 - SA - 70	21	
				QC 21 - SA - 9	9-89	
				QC 21 - SA - 77		

N/A

Handwritten: Not Used, per SD, 22/08/18, 51, 9-89

Part Op 100 - 1-Cut as per Dwg D Dwg Rev: F Prog Rev: P 2-Deburr if necessary
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - 1-Scuff surfaces with 80grit sandpaper per QSI 006 2-Deburr. No sharp edges
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	2.7777 sf (2.7777 ea)	100-Waterjet - Flow - 1	5232799

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	3	283	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	48.570inches ± 0.030	48.600 48.540		
2	Doubler	7.140inches ± 0.030	7.170 7.110		
3	Doubler	0.063inches ± 0.010	0.073 0.053		

Plex 8/11/20 12:08 PM Dart.Renwick.Jennifer



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S293648



Part: D3140-303

Job No: 212142

Serial No/Batch: S293648

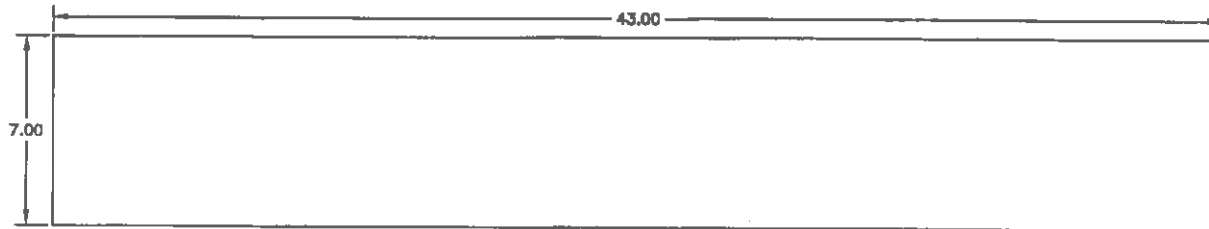
Revision:

Inspector:

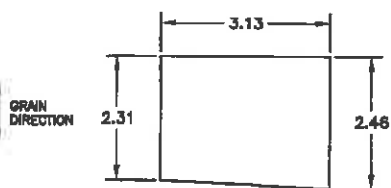
Exp Date:

Instructions: Various STC's

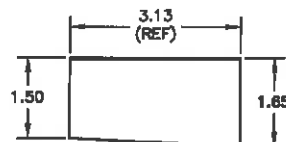
Date: 08/12/20



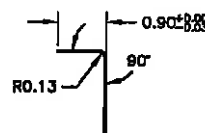
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



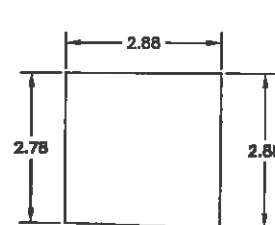
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



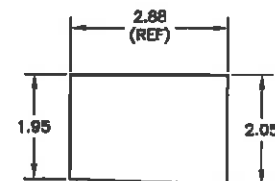
D3140-105 DOUBLER
D3140-106 OPPOSITE



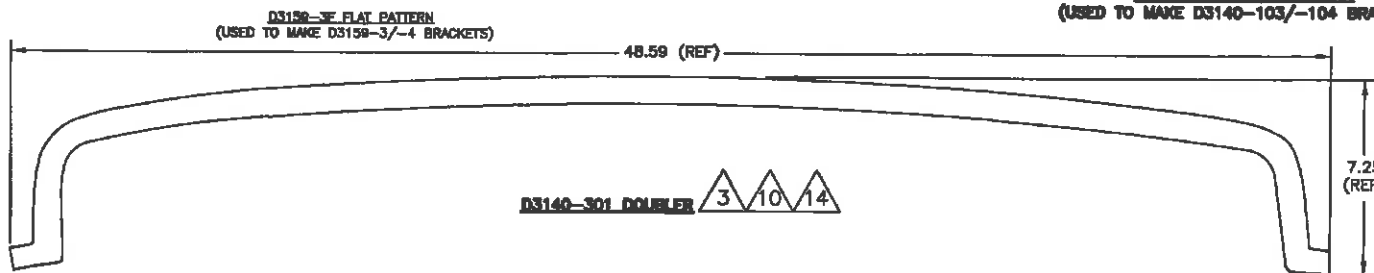
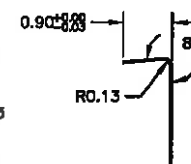
GRAIN
DIRECTION



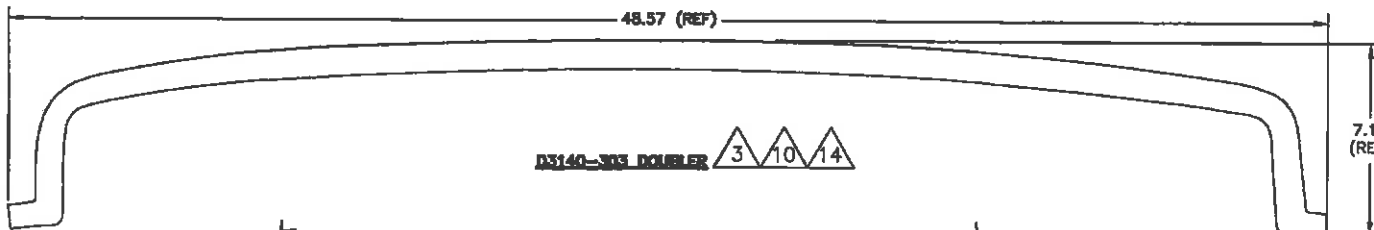
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



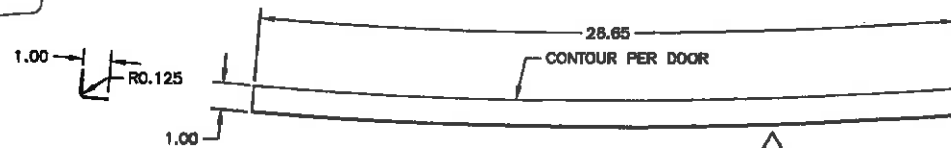
D3140-104 DOUBLER
D3140-103 OPPOSITE



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

06.11.17

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 212142

COPYRIGHT © 2008 BY DART AEROSPACE LTD.		DESIGN	4	DRAWN BY	CB		DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED		APPROVED		ISSUED FOR	D3140	REV. F
		DATE	06.10.06	TITLE		DOOR		SHEET 6 OF 7
								SCALE
								N/A

Entered:

Date:

28 Aug 18/2020



NCR No.

20-8305

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>22142</u> Part No. <u>D3140-303</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier Quality ☐																																			
Date: <u>20-8-12</u>		Sequence #: <u>100</u>		QTY Affected: <u>①</u>			MRB (QSI042) <u>INSP 12</u> <u>20/8/12</u>																																
Description Work Order Deviation				Disposition				Completed By <u>SM 20/09/12</u>																															
Reduce height of Part was 7.14 Ref Is 6.75. and per drawing height Reduce to 48.125 was 48.59 also Reduce width of the Part by 0.400 was 1.100 is 0.700 - Material change to 6061-T6-0.080 was 0.063 Scrap ONE Part, width was not to deviation				Acceptable. Shim for speedbar Seal.				Lead hand / Supervisor DAS 9 9-89 <u>20-8-12</u>																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☒ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>				☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☒ Fit/Function	☐ Off-set/Set-up		QC / QA Coordinator DAS 9 9-89 <u>20-8-12</u>			
☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong																																				
☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance																																				
☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing																																				
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish																																				
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing																																				
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread																																				
☐ Mislabeled	☒ Fit/Function	☐ Off-set/Set-up																																					
Other/Details:																																							